

Work Order ID 161559***161559***

Page 1

Thursday, May 18, 2017 11:40:47 AM

Item ID: D066-1003-011L02**Accept*****N900040100*****Setup Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** R66 Cabin Floor Protector - Black**Start Date:** 5/18/2017 **Start Qty:** 2.00***2*****Cust Item ID:****Required Date:** 6/19/2017 **Req'd Qty:** 2.00***2*****Customer:****Reference:**

Approvals: **Process Plan:** DAS 21 9-89 **Date:** MAY 18 2017 **Tooling:** **Date:**
QC: **Date:** **SPC (Y/N):** **Date:**

Run Start***NR1*****Stop*****NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D066-1003	B

100

100

DC

Doc.Control -USB or Paperwork

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D066-1003-011L02 CHG002

0.00

110

110

Packaging

Packaging

Pick Kit

Memo

0.00

0.00

120

120

QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

0.06

DAS
6
9-89**MAY 23 2017****DAS**
27
9-89**MAY 24 2017****DAS**
6
9-89**DAS**
28
9-89**MAY 23 2017****DAS**
27
9-89**MAY 23 2017**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause			FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	Past Due ☐							

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Thursday, May 18, 2017 11:40:47 AM

Item ID: D066-1003-011L02**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** R66 Cabin Floor Protector - Black**Start Date:** 5/18/2017 **Start Qty:** 2.00 ***2*****Cust Item ID:****Required Date:** 6/19/2017 **Req'd Qty:** 2.00 ***2*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: _____	0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D066-1003-011L02 Location : FG117 <i>fg 116</i>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.20							
Quality Control									

2 **DAS**
27
9-89
MAY 24 2017**DAS**
21
9-89**MAY 25 2017****DAS**
21
9-89**MAY 25 2017**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause			FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :						
Misidentified	☐	Past Due	☐							

Picklist Print

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Page 1

Work Order ID: 161559

161559

Parent Item: D066-1003-011L02

D066-1003-011L 02

Parent Item Name: R66 Cabin Floor Protector - Black

Start Date: 5/18/2017

Required Date: 6/19/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.02.05 NEW ISSUE DD VERF:JLM IPP Rev. B
Revise parts list 14/07/02 DL IPP REV:C 15.02.1 AS
PER IIN REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3580-3 *D3580-3* Joggle Bracket		Manufactured	No			110	Each	18.0000	6	12			DAr 6 9-89 DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST040				18					
				145423				18		12			
MS21059L3 *MS21059L 3* Nut Plate		Purchased	No			110	Each	84.0000	6	12			DAr 6 9-89 DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				GA				75					
				M137412				75					
				ST301				9					
				M137164				9		13758			
D4941-1L02 *D4941-1L 02* Floor Protector, Fwd LH, (Black)		Manufactured	No			110	Each	2.0000	1	2			DAr 6 9-89 DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST				2					
				159624				2		2			
D4941-2L02 *D4941-2L 02* Floor Protector, Fwd RH, (Black)		Manufactured	No			110	Each	2.0000	1	2			DAr 6 9-89 DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST				2					
				159626				2		2			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

Picklist Print

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Work Order ID: 161559

161559

Parent Item: D066-1003-011L02

D066-1003-011L02

Parent Item Name: R66 Cabin Floor Protector - Black

Start Date: 5/18/2017

Required Date: 6/19/2017

Start Qty: 2.00

Required Qty: 2.00

D4941-3L02 Manufactured No

110 Each 2.0000 1 2

D4941-3L02

Floor Protector, Aft LH, (Black)

**

MAY 23 2017

DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST

2

159628

2

D4941-4L02 Manufactured No

110 Each 2.0000 1 2

D4941-4L02

Floor Protector, Aft RH, (Black)

**

MAY 23 2017

DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST

2

159630

2

AN525-10R8 Purchased No

110 Each 285.0000 6 12

AN525-10R8

Screw

**

MAY 23 2017

DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

ST329

285

m135058

285

MS20426AD3-4 Purchased No

110 Each 7,980.000 12 24

MS20426AD3-4

RIVET

**

MAY 23 2017

DAS 28 9-89

DAS 27 9-89

Location

Loc Qty

Loc Code

GA

6270

m134294

1921

m136444

4349

ST312

1710

m134294

1710

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

4.0 WEIGHT AND BALANCE

The following is the weight increase associated with the D066-1003-XXX kits. Be sure to subtract the weight of any parts removed.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D066-1003-011L02 Cabin Floor Protector (Black Lexan Sheet)	6.7 lb 3.0 kg	0.10 in 0.00 m	0.67 in-lb 0.00 m-kg	43.72 in 1.11m	293 in-lb 3.33 m-kg
D066-1003-011L08 Cabin Floor Protector (Clear Lexan Sheet)	6.7 lb 3.0 kg	0.10 in 0.00 m	0.67 in-lb 0.00 m-kg	43.72 in 1.11m	293 in-lb 3.33 m-kg
D066-1003-013 Baggage Compartment Protectors	16.5 lb 7.5 kg	3.29 in 0.08 m	54 in-lb 0.60 m-kg	104.35 in 2.65 m	1721 in-lb 19.88 m-kg

5.0 PARTS LIST

Qty -011 L02	Qty -011 L08	Qty -013	Part Number	Description
X			D066-1003-011L02	CABIN FLOOR PROTECTORS (BLACK)
	X		D066-1003-011L08	CABIN FLOOR PROTECTORS (CLEAR)
		X	D066-1003-013	BAGGAGE COMPARTMENT PROTECTORS
1			D4941-1L02	FLOOR PROTECTOR, FWD LH
	1		D4941-1L08	FLOOR PROTECTOR, FWD LH
1			D4941-2 L02	FLOOR PROTECTOR, FWD RH
	1		D4941-2 L08	FLOOR PROTECTOR, FWD RH
1			D4941-3 L02	FLOOR PROTECTOR, AFT LH
	1		D4941-3 L08	FLOOR PROTECTOR, AFT LH
1			D4941-4 L02	FLOOR PROTECTOR, AFT RH
	1		D4941-4 L08	FLOOR PROTECTOR, AFT RH
		1	D4942-1	FLOOR PROTECTOR
		1	D4942-3	FORWARD WALL PROTECTOR
		1	D4942-7	LH WALL PROTECTOR
		1	D4942-9	DOOR PROTECTOR
		2	D4967-1	BRACKET
6	6		D3580-3	JOGGLE BRACKET
		3	D3580-5	JOGGLE BRACKET
		1	D5119-1	PLACARD
		1	D5120-1	PLACARD
6	6		AN525-10R8	SCREW
		10	AN525-10R9	SCREW
		8	CS62-1032-8CR	STUD, CLICK BOND
		3	AN970-3	WASHER
		8	MS21042-3	NUT, SELF LOCKING
		5	CB 200	3.5G ACRYLIC ADHESIVE
6	6	10	MS21059L3	NUTPLATE
12	12	20	MS20426AD3-4	RIVET

Work Order ID 161559

161559

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Thursday, May 18, 2017 11:40:47 AM

Item ID: D066-1003-011L02

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: R66 Cabin Floor Protector - Black

Start Date: 5/18/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/19/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

MAY 18 2017

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D066-1003	B								
100	Document Control								
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D066-1003-011L02 CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.06							
Quality Control									

DAS

6

9-00

MAY 23 2017

CA

CD

MAY 24 2017



Transport Canada Transports Canada

Department of Transport

Supplemental Type Certificate

This approval is issued to:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ontario
Canada K6A 1K7

Number: SH14-28

Issue No.: 1

Approval Date: June 20, 2014

Issue Date: June 26, 2014

Responsible Office:

Prairie and Northern

Aircraft/Engine Type or Model:

Robinson R66

Canadian Type Certificate or Equivalent:

H-111

Description of Type Design Change:

Interior Protector Kits

**Installation/Operating Data,
Required Equipment and Limitations:**

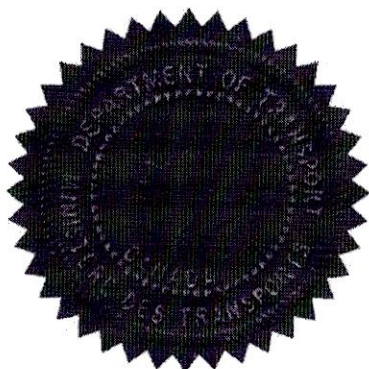
Installation of the Interior Protector Kits must be in accordance with Transport Canada Civil Aviation (TCCA) approved DART Aerospace Ltd. (DART) Installation Instructions IIN-D066-1003 Revision A, dated May 8, 2014 or later TCCA approved revision.

Maintenance of the Interior Protector Kits must be in accordance with TCCA accepted DART Instructions for Continued Airworthiness ICA-D066-1003 Revision 0, dated June 18, 2014 or later TCCA accepted revision.

Definition of the Type Design Change: TCCA approved DART Master Document List MDL-D066-1003 Revision A, dated June 20, 2014 or later TCCA approved revision.

Basis of Certification for Affected Areas: AWM Chapter 527, Change 527-8, dated June 30, 2009 (equivalent to 14 CFR Part 27 including amendments 27-1 through 27-44)..

— End —



Conditions: This approval is only applicable to the type/model of aeronautical product specified therein. Prior to incorporating this modification, the installer shall establish that the interrelationship between this change and any other modification(s) incorporated **will not** adversely affect the airworthiness of the modified product.

Scott W. Wales
For Minister of Transport

Canada